

Work Order ID 86845

86845

Page 1

July-06-12 3:11:12 PM

Item ID: D3214-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Placard

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-9

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3214

Rev B

100

0.00

100

Shear

Shear

SHEAR

Memo

0.00

Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg
D3214 Deburrl Identify as D3214-1

8

FF 12-10-01

110

0.00

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Smb
12 D.OIDAS
12
12/10/01

8

120

0.00

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

8

12-10-1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 86845

86845

Page 2

July-06-12 3:11:12 PM

Item ID: D3214-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Placard

Start Date: 7/06/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Powdercoat | | | | | | | | | |
| Powder Coating | | | | | | | | | |
| W121279 | Memo START TIME: 11:45 FINISH TIME: 12:15 | 0.00 | | | | | | | 12/10/02 |
| 140 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 150 | Small Fab | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HAAS 1 | | | | | | | | | |
| HAAS CNC vertical machine #1 | Memo Engrave text as per Folio FA394 and Dwg D3214 | 0.00 | | | | | | | FK 12/10/19. |

Dart Aerospace Ltd

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NOTE: Date & initial all entries

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12/10/22 

12-10-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

July-06-12 3:11:12 PM

Page 1

Work Order ID: 86845

Parent Item: D3214-1

Parent Item Name: Placard

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.04.15New issueKJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | | 110 | sf | 315.0443 | 0.0743 | 0.469263 | | | |
| 6061-T6 .080 Sheet | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT021 | | 315.044316 | | | | | | | |
| | | | | 117285 | | 0.124316 | | | | | | | |
| | | | | 119766 | | 39.6 | | | | | | | |
| | | | | 120096 | | 261.62 | | | | | | | |
| | | | | <u>121193</u> | | 13.7 | | | | | | | |
| | | | | | | | | | 0.5944 | | | | |

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NOTE: Date & initial all entries

DART

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|------------------|-------------------------|---|------------------------|
| DESIGN T# | DRAWN BY C.B. | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED [Signature] | DRAWING NO. D3214 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE PLACARD | SCALE 1:1 |
| A | 04.01.27 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

RELEASED

06.06.20 [Signature]

**D3214-1**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 808415

NOTES

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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